

Ship Nov. 4

Work Order ID 108953

108953

Page 1

October-30-13 10:03:09 AM

Item ID: D3868-5

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Spacer

Start Date: 10/30/13 Start Qty: 10.00 *10*

Cust Item ID:

Required Date: 11/04/13 Req'd Qty: 10.00 *10*

Customer:

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
<i>D3868</i>	<i>Rev A</i>								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3868 Dwg Rev: <i>N/A</i> A Prog Rev: <i>N/A</i> A 2-Deburr if necessary								<i>13.10.30</i>
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									<i>13.10.30</i>
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									<i>13.10.31</i>

DAS
27
9-89

10 0 A
13.10.30

10 0 A
13.10.30

K

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10

Cust Item ID:

Required Date: 11/04/13 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

10x 13/11/01 DAS 36 9-89

10x DAS 28 9-89 13-11-1

MLG 1371-04

u(3.1004

Picklist Print

October-30-13 11:25:57 AM

Page 1

Work Order ID: 108953

Parent Item: D3868-5

Parent Item Name: Spacer

Start Date: 10/30/13

Required Date: 11/04/13

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 09-01-19 as per prelim issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040 6061-T6 .040 Sheet		Purchased	No				sf	403.6000		0.1		13.10.30	

Location

Loc Qty

Loc Code

MAT021

403.6

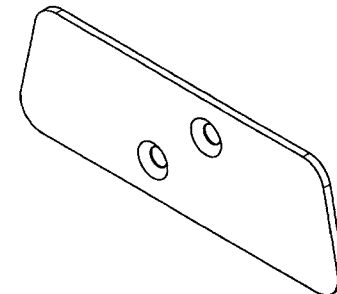
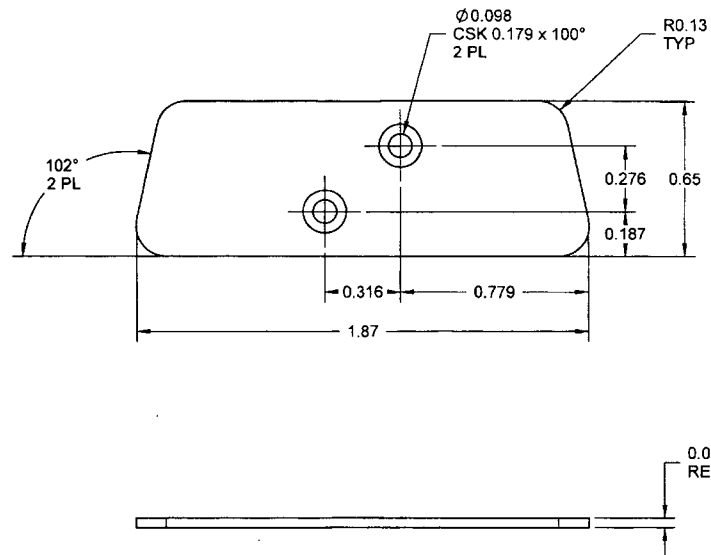
m126350

211.6

m126981

192

126350 → 0.1









D3868-5 SPACER

RELEASED
09/01/13

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: LESS THAN 0.01 Lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3868	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SPACER	NTS
DATE	09.01.13	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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